

Date: Monday, 11/21/2005 12:41:19 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOW DIVIDER
Job Number : 24768	
Estimate Number : 10806	
P.O. Number : N/A	Part Number : D2377041
This Issue : 11/21/2005 S.O. No. : N/A	Drawing Number : D2377 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 12/15/2005
Checked & Approved By : SEE ABOVE USER & DATE	Qty: 10 Um: Each
Comment : Est Rev:B 03.02.28 Reformat; Incorporated D2377-01 & D2377-03 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T3000W049	6061-T6 Tube 3.00 x.049W



Comment: Qty.: 0.7875 f(s)/Unit Total : 1.5750 f(s)
 Material: 6061-T6 Seamless Tubing Ø3.00" x 0.049" wall
 M6061T6T3.000W.049)
 Batch: M18211

u 060313

FF 05.12.01

10

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut 6.000" Long as per Dwg D2377
 Identify as D2377-01

FF 05.12.01

2-Cut 3.000" Long as per Dwg D2377
 Identify as D2377-03

FF 05.12.01

3-For D2377-01 cut hole as per Dwg D2377

FF 05.12.01

4-Deburr

FF 05.12.01

5-For D2377-03 shape one end as per Dwg D2377

AA 06/01/04

10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PD 06-01-04 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 27 Date: 26/5/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 12:41:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOW DIVIDER

Job Number: 24768

Part Number: D2377041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2377-01 & D2377-03 as per Dwg D2377 Remove inside edge

A/R AL ROD Batch: M18838

MOG/15/11

(19)

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-05-11

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

q.m 06-05-15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC

06 05 15

(10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 176

PC 6/5/16

(10)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/17

(18)

Job Completion



u 06-05-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

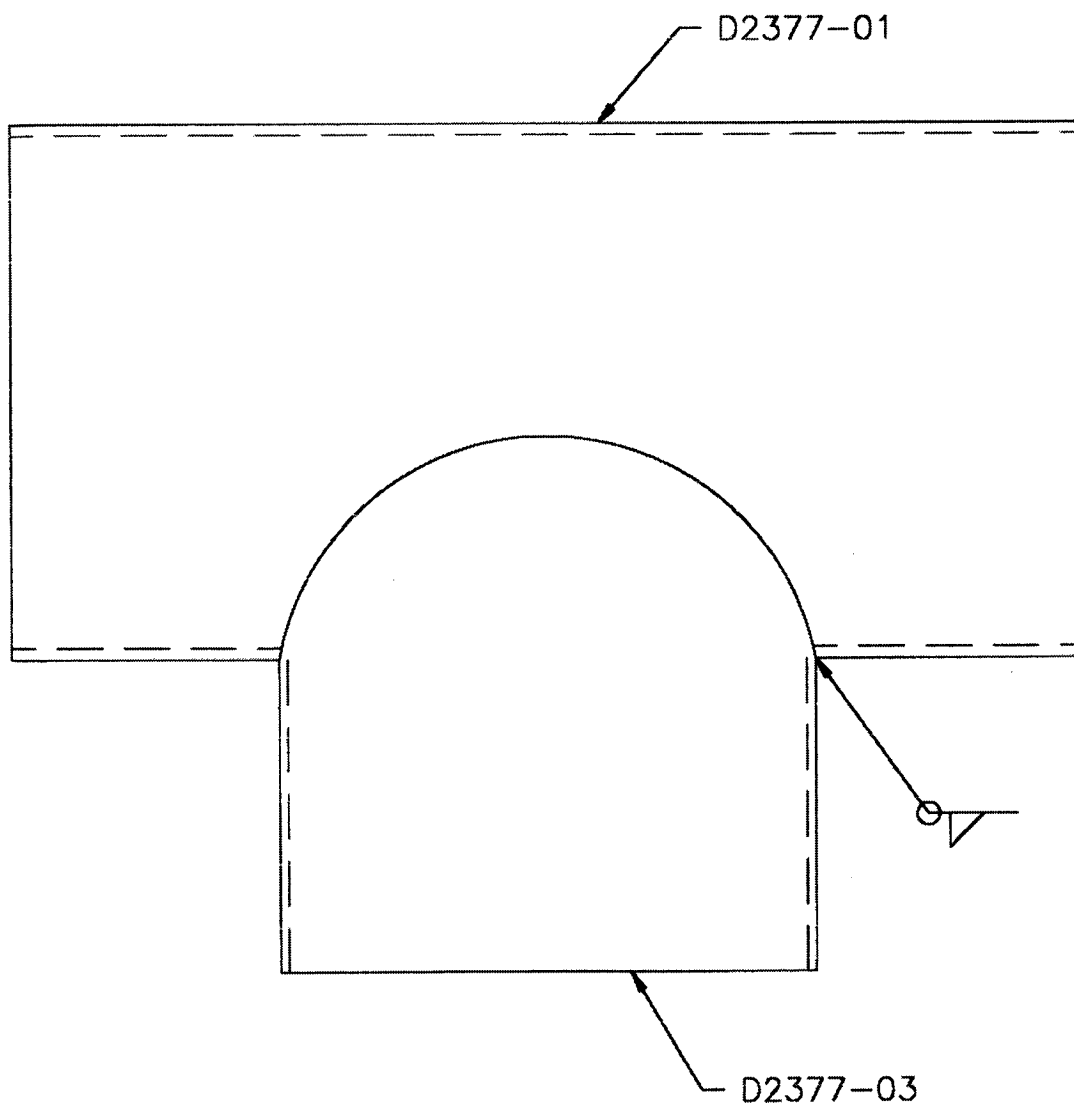
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BWS	APPROVED BWS	D2377	REV. A SHEET 1 OF 3
DATE Apr. 18, 1995		TITLE DISTRIBUTION BOX	SCALE 1:1

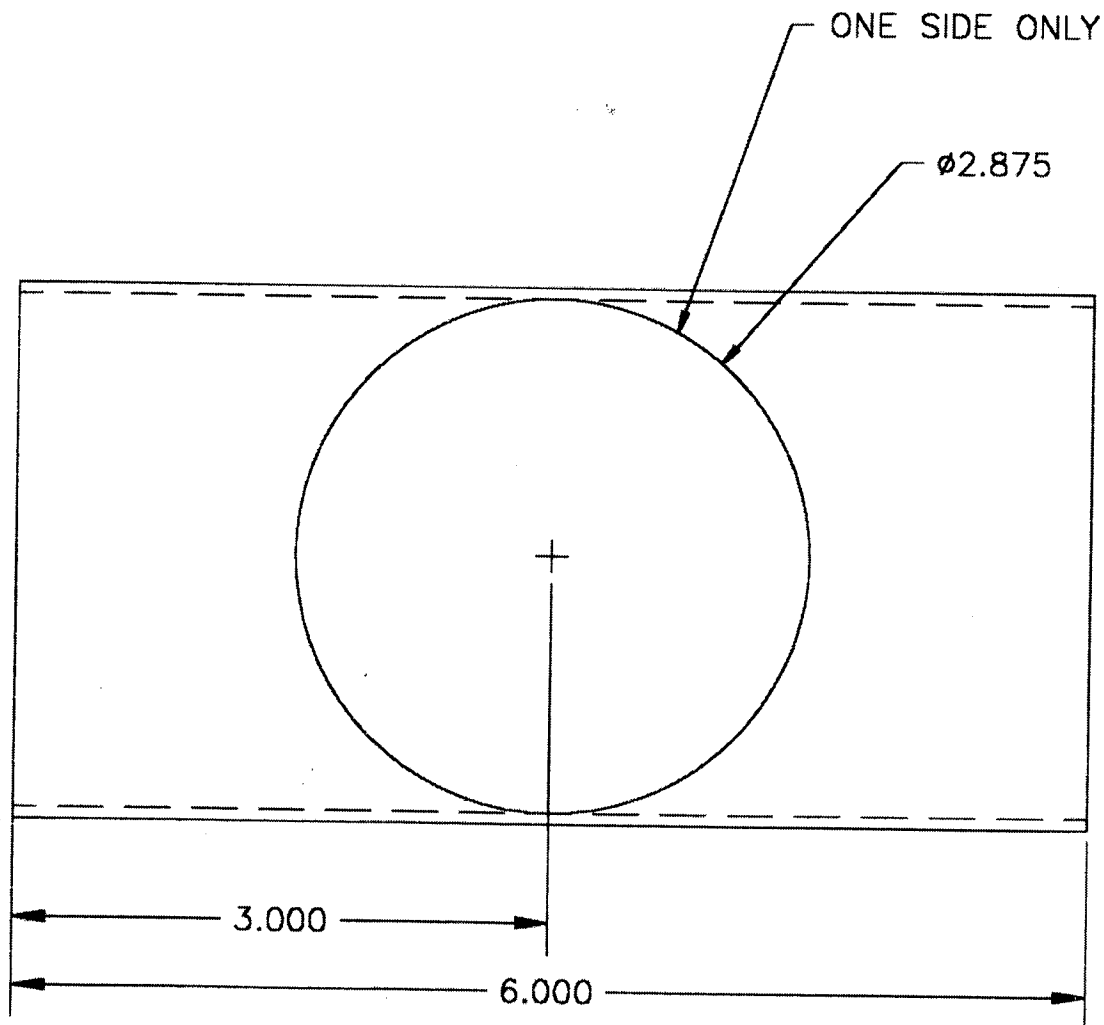
RELEASED
7669/10 BWS





PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2377	REV. A SHEET 2 OF 3
DATE Apr. 18, 1995		TITLE DISTRIBUTION BOX SCALE 1:1	

RELEASED
76-9/10 BW

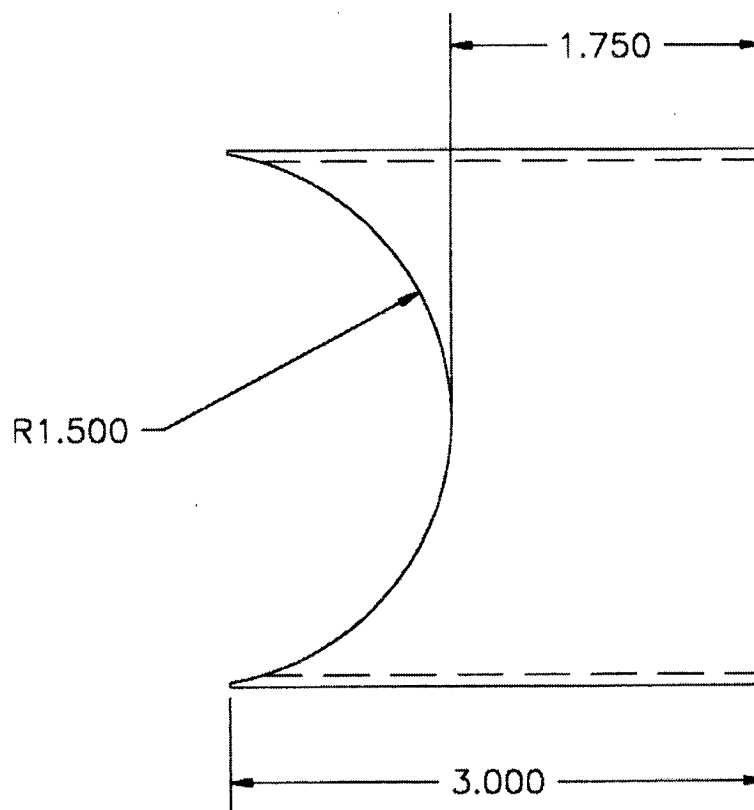


D2377-01
MATERIAL: 6061-T6 SEAMLESS TUBE
3" DIAM 0.049 WALL CUT 6" LONG

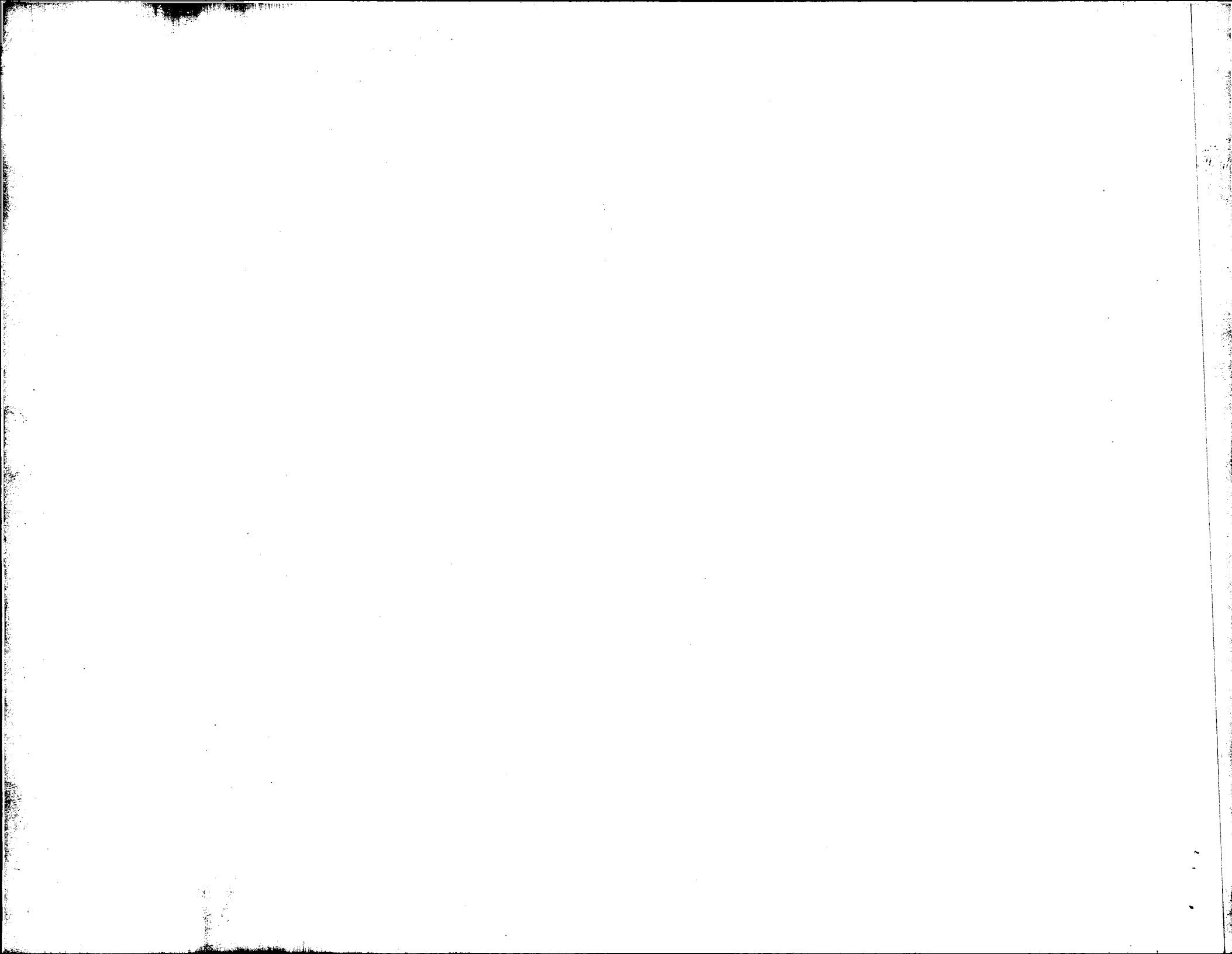


PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2377	REV. A SHEET 3 OF 3
DATE Apr. 18, 1995		TITLE DISTRIBUTION BOX	SCALE 1:1

RELEASED
9/6/95 BW



D2377-03
MATERIAL: 6061-T6 SEAMLESS TUBE
3" DIAM 0.049 WALL CUT 3" LONG



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024768	Department Code:	
Project Name	:	D2377-041	Burden Flags	: NNNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2377-041	Invoice Number	:
Description	:	Distribution Box	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	2	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00